

Rush

Work Order ID 148794-2

148794

Page 1

July 08, 2016 10:34:16 AM

Item ID: PB67-43001-27

SPLIT

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blade Positioner

Start Date: 7/8/2016 Start Qty: 3.00

23 *** STA
23 ***

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: SH Date: 7/12/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001-27	Rev C
--------------	-------

100

0.00

100

Small Fab

Small Fab

Memo

0.55

Small Fab

1- slide -289 , -291 and -293 on -19 tube then slide it in -285 tube2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg 3- assemble all parts as per dwg PB67-43001

2 AUG 29 2016

DAS
24
9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.01

Quality Control

2

DAS
30
9-89
AUG 30 2016

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.01

Packaging

PPP 150734
PPP 150015

2x DAS
28
9-89
DAS
27
9-89

AUG 30 2016

Work Order ID 148794

July 08, 2016 10:34:16 AM

148794

Page 2

Item ID: PB67-43001-27 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Blade Positioner
Start Date: 7/8/2016 Start Qty: 3.00 *3* Cust Item ID:
Required Date: 8/3/2016 Req'd Qty: 3.00 *3* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.05							
Quality Control									

DAS
21
9-89

SEP 01 2016

mf
16-8-31

Picklist Print

July 08, 2016 10:34:15 AM

Page 1

Work Order ID: 148794

148794

Parent Item: PB67-43001-27

PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
C 10.09.28 per rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-19		Manufactured	No			100	Each	4.0000	1	3			
PB67-43001-19										**	3	7	C
Inner Tube And Retainer Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				4					
				142399				4					
PB67-43001-29		Manufactured	No			100	Each	3.0000	1	3			
PB67-43001-29										**	3	7	C
Blade Positioner Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				3					
				142353				3					
PB67-43001-31		Manufactured	No			100	Each	6.0000	1	3			
PB67-43001-31										**	3	1	C
Upper Restraint Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				6					
				111808				5					
				114031				1					
PB67-43001-35		Manufactured	No			100	Each	5.0000	1	3			
PB67-43001-35										**	3	1	C
Lower Pad Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				5					
				111762				5					

3149628 → 2
AUG 29 2016

DAS
24
9-00

Picklist Print

July 08, 2016 10:34:15 AM

Page 2

Work Order ID: 148794

148794

Parent Item: PB67-43001-27

PR67-43001-27

Parent Item Name: Blade Positioner

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-285

Manufactured No

100

Each

3.0000

1

3

**

PR67-43001-285

Upper Tube, Blade Positioner

Location

Loc Qty

Loc Code

Mezz2

3

139264

3

100

Each

5.0000

1

3

**

PB67-43001-289

Manufactured No

PR67-43001-289

Stationary Handle Adjustment Fitting

Location

Loc Qty

Loc Code

Mezz2

5

142349

5

100

Each

6.0000

1

3

**

PB67-43001-291

Manufactured No

PR67-43001-291

Clamp Bushing

Location

Loc Qty

Loc Code

Mezz2

6

114030

6

100

Each

5.0000

1

3

**

PB67-43001-293

Manufactured No

PR67-43001-293

Extension Tube Adjustment Fitting

Location

Loc Qty

Loc Code

Mezz2

5

139263

5

100

Each

15.0000

1

3

**

AN6-22A

Purchased No

AN6-22A

BOLT

Location

Loc Qty

Loc Code

ST334

15

M128403

15

DAS
8
9-89

JUL 26 2016

July 08, 2016 10:34:15 AM

Shop Packet Print

Page 2

Picklist Print

July 08, 2016 10:34:15 AM

Page 3

Work Order ID: 148794

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

148794

PB67-43001-27

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L6

Purchased

No

100

Each

221.0000

1

3

MS21042L6

Nut

**

~~1~~ (3)

Location

Loc Qty

Loc Code

DAS
6
9-89

ST303

221

m133938

6

m134055

5

m134676

50

m134955

100

m135058

60

~~1~~

MS27039-1-04

Purchased

No

100

Each

202.0000

3

9

MS27039-1-04

Screw

**

~~1~~ ~~1~~ (9)

Location

Loc Qty

Loc Code

DAS
6
9-89

ST281

202

m134634

2

m135015

200

~~1~~

MS27039-1-08

Purchased

No

100

Each

404.0000

1

3

MS27039-1-08

Screw

**

~~1~~ (3)

Location

Loc Qty

Loc Code

DAS
6
9-89
JUL 26 2016

FP001

73

m128636

73

GA

72

125654

1

m128636

71

ST281

259

m134762

259

~~1~~

Picklist Print

July 08, 2016 10:34:15 AM

Page 4

Work Order ID: 148794

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

148794

PR67-43001-27

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS27039-1-09

Purchased

No

100

Each

285.0000

6

18

MS27039-1-09

Screw

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

34

18057

34

GA

36

124859

36

ST280

215

m134167

15

m135056

200

~~15~~ 15

MS51859-8

Purchased

No

100

Each

276.0000

2

6

MS51859-8

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

st268

276

m134606

276

NAS1149F0316P

Purchased

No

100

Each

143.0000

7

21

NAS1149F0316P

WASHER

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

143

M132579

143

NAS1149F0363P

Purchased

No

100

Each

329.0000

3

9

NAS1149F0363P

WASHER

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

329

124555

329

JUL 26 2016

July 08, 2016 10:34:16 AM

Shop Packet Print

Page 4

Picklist Print

July 08, 2016 10:34:16 AM

Page 5

Work Order ID: 148794

Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

148794

PR67-43001-27

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149F0632P

Purchased

No

100

Each

175.0000

2

6

NAS1149F0632P

WASHER

**

Location

Loc Qty

Loc Code

ST262

175

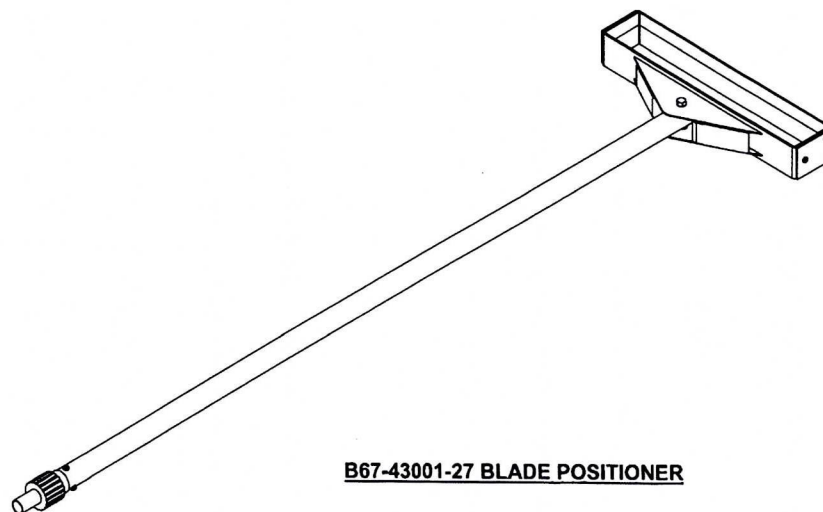
18057

4

m134497

171

JUL 26 2016



B67-43001-27 BLADE POSITIONER

NOTES:

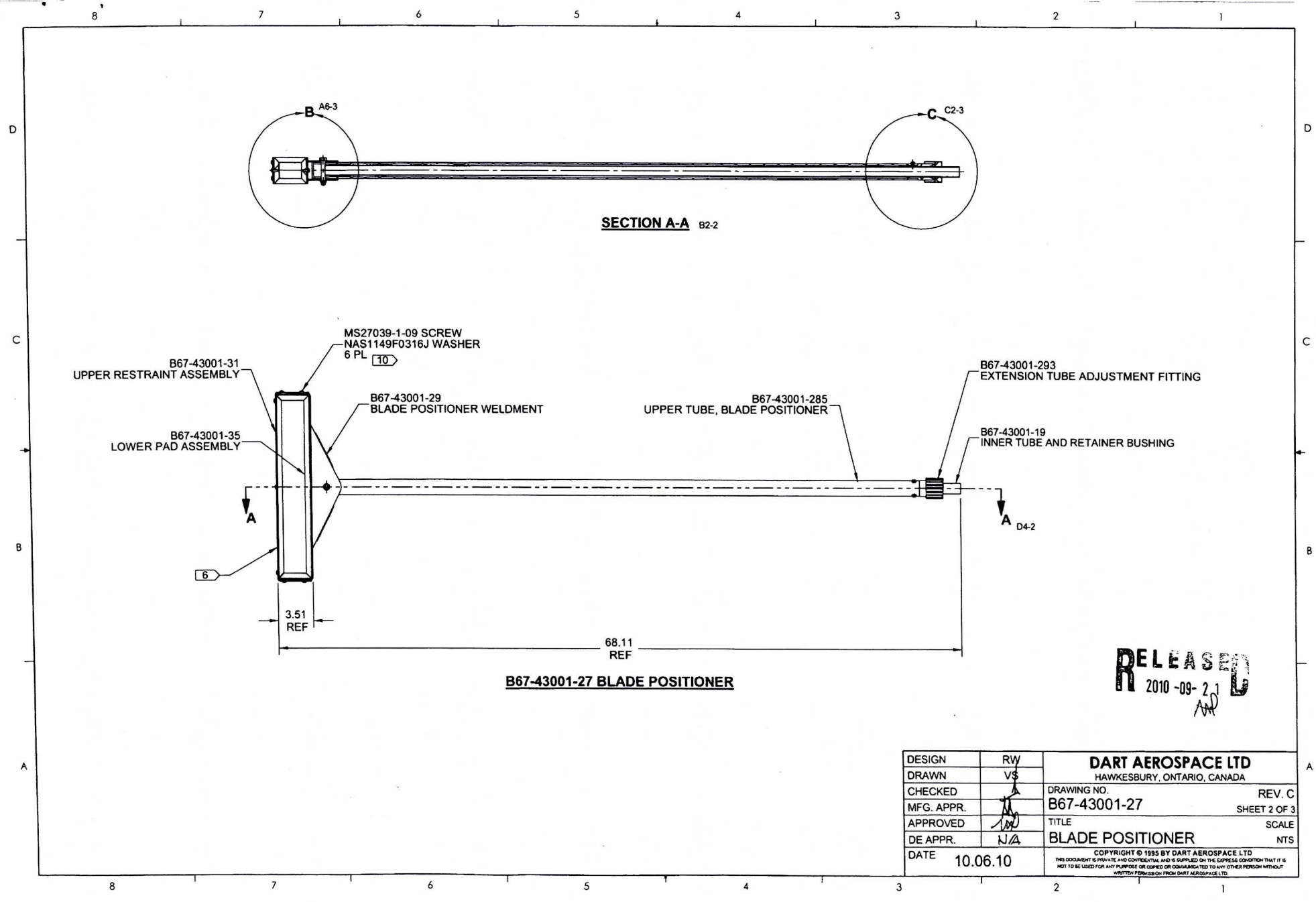
- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 7.07 lbs
- 8) DRILL THRU B67-43001-285/-289 PRIOR TO ASSEMBLY
- 9) DO NOT TORQUE NUT ON BOLT: TIGHTEN UNTIL SNUG
- 10) MATCH DRILL $\varnothing$ 0.193 HOLE THRU B67-43001-29 WITH NUTPLATES LOCATED ON B67-43001-35

ITEM	QTY. -27	P/N	DESCRIPTION
	X	B67-43001-27	BLADE POSITIONER
1	1	B67-43001-19	INNER TUBE AND RETAINER BUSHING
2	1	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-31	UPPER RESTRAINT ASSEMBLY
4	1	B67-43001-35	LOWER PAD ASSEMBLY
5	1	B67-43001-285	UPPER TUBE, BLADE POSITIONER
6	1	B67-43001-289	STATIONARY HANDLE ADJUSTMENT FITTING
7	1	B67-43001-291	CLAMP BUSHING
8	1	B67-43001-293	EXTENSION TUBE ADJUSTMENT FITTING
9	1	AN6-22A	BOLT
10	1	MS21042L6	NUT
11	3	MS27039-1-04	SCREW
12	1	MS27039-1-08	SCREW
13	6	MS27039-1-09	SCREW
14	2	MS51859-8	WASHER
15	7	NAS1149F0316P	WASHER
16	3	NAS1149F0363P	WASHER
17	2	NAS1149F0632P	WASHER

SH 148794
7/12/16

RELEASED
2010-09-26

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 4 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		VS	10.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-27 TITLE BLADE POSITIONER REV. C SHEET 1 OF 3 SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		
DRAWN	VS			
CHECKED	JS			
MFG. APPR.	JS			
APPROVED	MP			
DE APPR.	UA			
DATE	10.06.10			



SECTION A-A B2-2

B67-43001-31
UPPER RESTRAINT ASSEMBLY

MS27039-1-09 SCREW
NAS1149F0316J WASHER
6 PL 10

B67-43001-35
LOWER PAD ASSEMBLY

B67-43001-29
BLADE POSITIONER WELDMENT

B67-43001-285
UPPER TUBE, BLADE POSITIONER

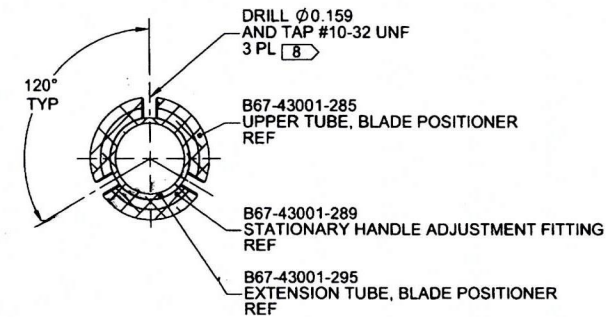
B67-43001-293
EXTENSION TUBE ADJUSTMENT FITTING

B67-43001-19
INNER TUBE AND RETAINER BUSHING

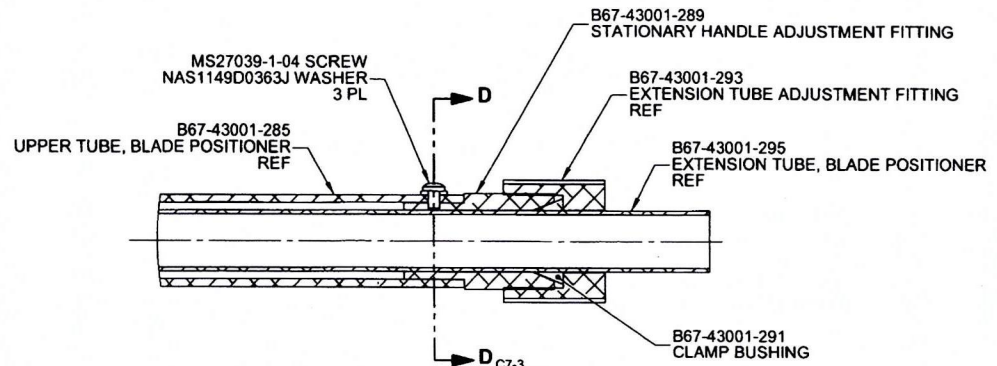
B67-43001-27 BLADE POSITIONER

RELEASED
2010-09-21
AND

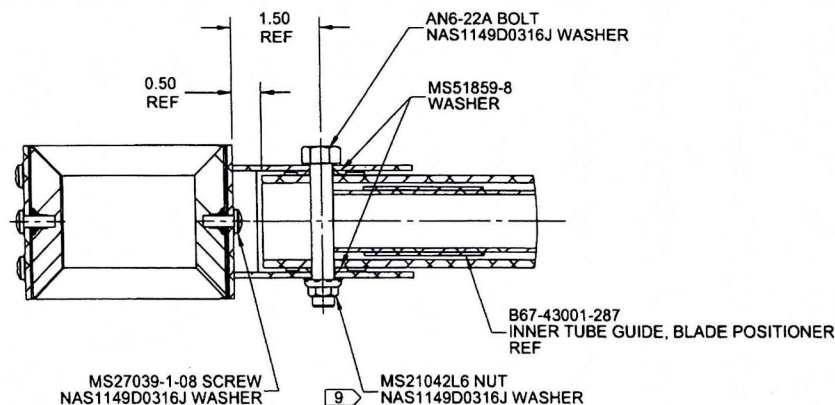
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	BLADE POSITIONER	NTS
DATE	10.06.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION D-D C3-3
(HARDWARE NOT SHOWN FOR CLARITY)



DETAIL C D3-2
SCALE 4X



DETAIL B D7-2
SCALE 4X

RELEASED
2010-09-21
JP

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	NA	BLADE POSITIONER	NTS
DATE	10.06.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			